

Work Order ID 56912

March 12, 2010 1:28:29 PM

Page 1

Item ID: D3706-3

Accept

Revision ID:

Item Name: Guide

Start Date: 12/03/2010 Start Qty: 10.00

Required Date: 26/03/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: *PL*

Date: *10-3-15* Tooling:

QC:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3706

Rev A

100



Doosan

Doosan Lathe

DOOSAN
CONVENTIONAL LATHE *N/A* *Full*

Memo

Turn as per Dwg D3706 and Folio FA833

DWG REV: *A*

FOLIO REV: _____

DEBURR

0.00

0.00

SL *10/03/22* *(10)*

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

SL *10/03/22*

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Page 2

Item ID: D3706-3

Accept



Setup Start



Revision ID:

Item Name: Guide

Stop



Start Date: 12/03/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 26/03/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

SP 10/03/22

10

10

Quality Control

150

Identify as per dwg & Stock Location: 84

0.00



Packaging

Memo

0.00

Packaging

10/03/22 (10)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/24

10-3-22 (10)

Picklist Print

March 12, 2010 1:28:34 PM

Page 1

Work Order ID: 56912

Parent Item: D3706-3

Parent Item Name: Guide

Start Date: 12/03/2010

Required Date: 26/03/2010

Comments: IPP Rev:A New Issue 08-06-04 JLM Verified By:EC
REV:B Now on Doosan JLM 10-01-13 Verified By:EC IPP

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased	No			100	f	26.0270	4.5263			



6061-T6 Round Bar .500"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

26.027

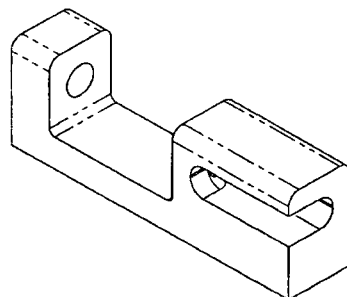
110532

24

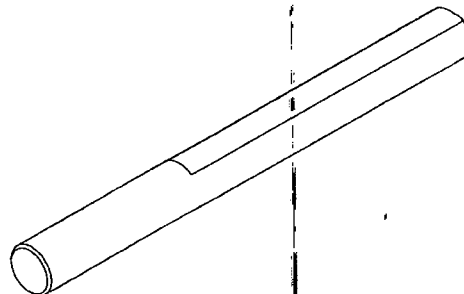
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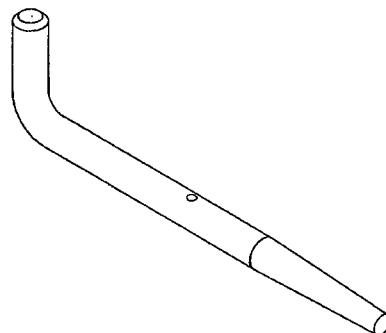
H-6 SL 10/03/22



D3706-1 LOCK BRACKET



D3706-3 GUIDE



D3706-5 PIN

SHOP COPY
RETURNED
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

56812
10-3-15

RELEASED
09/02/05

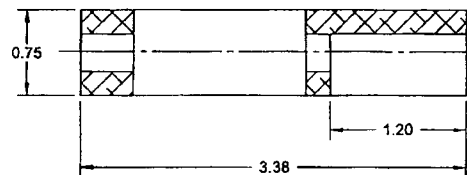
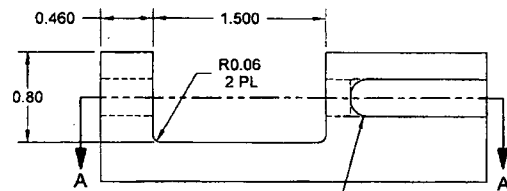
REV.	NEW ISSUE	DESCRIPTION	MB	08.05.26
DESIGN			BY	DATE
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.05.26			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3706** REV. A
SHEET 1 OF 4

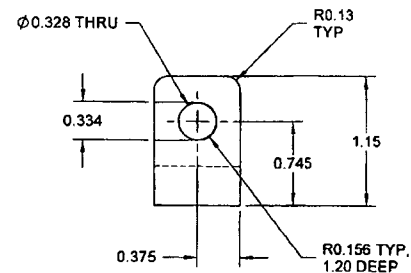
TITLE **INSTRUMENT PANEL LOCK** SCALE
NTS

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SECTION A-A

D3706-1 LOCK BRACKET



W/056912

RELEASED
8/12/05 N/P

D3706-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

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MFG APPR.		D3706	SHEET 2 OF 4
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DE APPR.		INSTRUMENT PANEL LOCK	NTS
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Ø0.50



0.450

3.38

0.03 X 45°
TYP

5.25

D3706-3 GUIDE

W/O 56912

RELEASED
07/02/05 VHP

D3706-3 GUIDE NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC. M6061T6R0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

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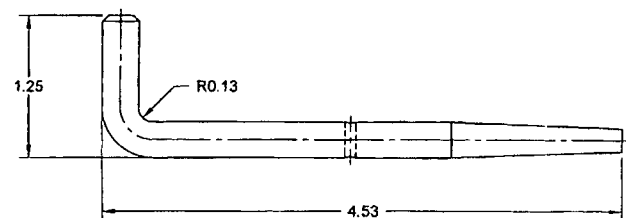
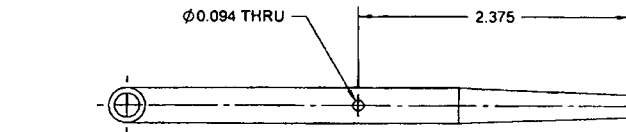
8 7 6 5 4 3 2 1

D D

C C

B B

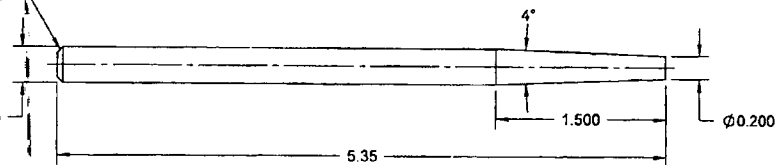
A A



D3706-5 PIN
(MAKE FROM D3706-5F)

0.05 X 45°
CHAMFER

Ø0.313



D3706-5F PIN

W/O 56912

RELEASED
07/12/05

D3706-5 NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR
(REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

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8 7 6 5 4 3 2 1